



Dart Hawkesbury  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D4635-144**  
**Job Sheet 167086-F**



Part No: D4635-144

Job Qty: 1 ea

Part Name: Aft Ceiling Replacement Panel Assembly, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |
| 90    | Start up Operation | 1 Ea  |            | 11/9/17  | 0.00      | 0.00    | Start up container    |           |
| 100   | HandThermo         | 1 pcs |            | 11/9/17  | 0.00      | 1.16    | HandFinish4           |           |
| 110   | Small Fab          | 1 pcs |            | 11/10/17 | 0.00      | 1.57    | Small Fab             |           |
| 120   | QC                 | 1 pcs |            | 11/10/17 | 0.00      | 0.00    | QC5                   |           |
| 130   | Packaging          | 1 pcs |            | 11/10/17 | 0.00      | 0.00    | Packaging3            |           |
| 140   | QC21-SA            | 1 Ea  |            | 11/10/17 | 0.00      | 0.00    | QC21                  |           |

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4635-144 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: \_\_\_\_\_ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # \_\_\_\_\_ Expiry Date \_\_\_\_\_ 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: \_\_\_\_\_

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: \_\_\_\_\_

140 - QC21- Final Inspection - Work Order Release

### Job Allocations

| Operation             | Component Part          | Required | Inventory | Allocated | Std Qty |
|-----------------------|-------------------------|----------|-----------|-----------|---------|
| 90-Start up Operation | D4635-4 <i>S022775</i>  | 1        | 2         | 0         | 0       |
|                       | D4669-1                 | 1        | 27        | 0         | 0       |
|                       | D4695-4 <i>S0221329</i> | 1        | 2         | 0         | 0       |
|                       | D4732-11 <i>S022774</i> | 1        | 5         | 0         | 0       |
|                       | D4732-39 <i>S022773</i> | 1        | 6         | 0         | 0       |
|                       | D4732-41 <i>S022772</i> | 1        | 6         | 0         | 0       |
|                       | D5022-5 <i>S022770</i>  | 1        | 2         | 0         | 0       |

### Part Specifications

Specifications could not be found.

Plex 10/24/17 11:08 AM dart.poulin.mario

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                      | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div>                                          |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                |                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                              |
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padding: 5px; transform: rotate(-15deg); display: inline-block;">             Job No: 167086-F<br/>             Mfg Date: 12/22/17           </div> <div style="margin-top: 20px; text-align: center;"> <b>Start up Operation</b><br/> <b>D4635 - 144</b><br/> <b>Part No: D4635</b><br/> <b>Revision: 144</b><br/> <b>Operation: 144</b><br/> <b>Change No: 144</b> </div> <div style="text-align: center; margin-top: 20px;"> <b>Art Ceiling Replacement Panel Assembly, RH</b> </div> <div style="text-align: center; margin-top: 20px;"> <br/> <b>S026631</b><br/> <b>DART AEROSPACE</b> </div> <div style="margin-top: 20px;"> <p>1270 Aberdeen Street<br/>             Hawkesbury, ON K6A 1K7<br/>             CANADA<br/>             TEL: 1 613 632-5200<br/>             Email: sales@dartaero.com<br/>             www.dartaerospace.com</p> </div> |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                |                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                              |
| <b>Root Cause</b><br><table style="width:100%;"> <tr> <td style="width:50%;">           Environment <input type="checkbox"/><br/>           Design <input type="checkbox"/><br/>           Doc/Data <input type="checkbox"/><br/>           Equip/Tooling <input type="checkbox"/><br/>           Handling/Pre <input type="checkbox"/><br/>           Material <input type="checkbox"/><br/>           Internal Transport <input type="checkbox"/><br/>           Tribal Knowledge <input type="checkbox"/><br/>           LOA <input type="checkbox"/><br/>           Substation <input type="checkbox"/><br/>           Past Expiry Date <input type="checkbox"/><br/>           Misidentified <input type="checkbox"/> </td> <td style="width:50%;">           No Re-verification <input type="checkbox"/><br/>           Operator <input type="checkbox"/><br/>           Offset/Setup <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Training <input type="checkbox"/><br/>           Use for Testing <input type="checkbox"/><br/>           Poor Information <input type="checkbox"/><br/>           Rushing <input type="checkbox"/><br/>           Product Improvement <input type="checkbox"/><br/>           Process Improvement <input type="checkbox"/><br/>           Manufacturing Process <input type="checkbox"/><br/>           Past Due <input type="checkbox"/> </td> </tr> </table> |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Environment <input type="checkbox"/><br>Design <input type="checkbox"/><br>Doc/Data <input 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<input type="checkbox"/><br>Training <input type="checkbox"/><br>Use for Testing <input type="checkbox"/><br>Poor Information <input type="checkbox"/><br>Rushing <input type="checkbox"/><br>Product Improvement <input type="checkbox"/><br>Process Improvement <input type="checkbox"/><br>Manufacturing Process <input type="checkbox"/><br>Past Due <input type="checkbox"/> | <table style="width:100%;"> <tr> <td style="width:50%;">           Crimp/Kink/Ripple/Wave <input type="checkbox"/><br/>           Cuffs <input type="checkbox"/><br/>           Crushing <input type="checkbox"/><br/>           Heat Treat <input type="checkbox"/><br/>           Wave/Twist in Tube <input type="checkbox"/><br/>           Marks/Chatter <input type="checkbox"/> </td> <td style="width:50%;">           Contamination <input type="checkbox"/><br/>           Countersink <input type="checkbox"/><br/>           Cut Too Short <input type="checkbox"/><br/>           Instructions Incomplete/Unclear <input type="checkbox"/><br/>           Drill Holes <input type="checkbox"/> </td> </tr> </table> |                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                | Crimp/Kink/Ripple/Wave <input type="checkbox"/><br>Cuffs <input type="checkbox"/><br>Crushing <input type="checkbox"/><br>Heat Treat <input type="checkbox"/><br>Wave/Twist in Tube <input type="checkbox"/><br>Marks/Chatter <input type="checkbox"/> | Contamination <input type="checkbox"/><br>Countersink <input type="checkbox"/><br>Cut Too Short <input 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